

Work Order ID 76457-1

76457

November-15-11 8:03:46 AM

Page 1

Item ID: D407-802-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Passenger Door Opener Installation, LH

Start Date: 15/11/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/11/15

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-017 CHG001

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

shp 25/01

Split IX

8/24/27

JB

dx

sp 12-01-26

8/24/27

ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76457

76457

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November-15-11 8:03:46 AM

Item ID: D407-802-017 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Passenger Door Opener Installation, LH
 Start Date: 15/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging	0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPPD407-802-017								
	Location: <u>A</u>								
	PPP rev: <u>11</u>								
130		0.00							
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo								
Quality Control									

(12) *12/04/30*
MLJ 12/04/30
MLJ 12/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

November-15-11 8:03:51 AM

Page 1

Work Order ID: 76457

76457

Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17

Manufactured

No

105

Each

23.0000

1

2

D3552-17

Door Prop

**

Location

Loc Qty

Loc Code

ST272

11

64338

4

65120

7

ST276

12

69670

12

D3622-5

Manufactured

No

105

Each

12.0000

1

2

D3622-5

Ball Stud

**

Location

Loc Qty

Loc Code

ST070

12

65087

12

D4108-1

Manufactured

No

105

Each

5.0000

1

2

D4108-1

Door Doubler, Left

**

Location

Loc Qty

Loc Code

st128

5

62301

1

64484

4

So

2x

B80406 sp

B79343 sp

12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 76457

76457

Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

D4108-049

Manufactured No

105 Each

2.0000

1 2

D4108-049

Litter Door Fitting Assembly

**

B 793531x 8p
12-04-27.

Location

Loc Qty

Loc Code

ST129

2

64490

2

CR3523-4-03

Purchased No

105 Each

90.0000

21 42

CR3523-4-03

RIVET

**

m120521 8p

Location

Loc Qty

Loc Code

ST314

90

112991

10

116373

80

MS20426AD4-5

Purchased No

105 Each

5,242.000

2 4

MS20426AD4-5

Rivet

**

JB

Location

Loc Qty

Loc Code

MEZZ

165

6733

165

ST317

5077

6874

5077

MS21073L5

Purchased No

105 Each

73.0000

1 2

MS21073L5

nut plate

**

JB 12/04/25

Location

Loc Qty

Loc Code

ST302

73

117395

73

117395

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 76457

76457

Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

MS21209F1-15

Purchased

No

105

Each

5.0000

3

6

MS21209F1-15

HELI COIL

**

m 12/16/6 SP

Location

Loc Qty

Loc Code

ST304

5

104537

5

MS27039C1-06

Purchased

No

105

Each

68.0000

3

6

MS27039C1-06

Screw

**

SP

Location

Loc Qty

Loc Code

ST293

68

115768

68

MS27039C1-09

Purchased

No

105

Each

128.0000

1

2

MS27039C1-09

SCREW

**

JB

Location

Loc Qty

Loc Code

FP-B

28

17831

28

ST293

100

116290

100

MS27039C1-27

Purchased

No

105

Each

35.0000

2

4

MS27039C1-27

Screw

**

JB 12/04/25

Location

Loc Qty

Loc Code

ST293

35

115768

35

115768

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 76457

76457

Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

105

Each

2,056.000

2

4

✓

NAS1149C.0332R

Washer

**

121509 JB

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

2049

116304

55

117460

18

117887

169

118078

2

118179

78

118354

987

119124

740

NAS1149C1165R

Purchased

No

105

Each

85.0000

2

4

✓

NAS1149C.1165R

Washer

**

JB

Location

Loc Qty

Loc Code

ST296

85

115768

85

NAS1149C0532R

Purchased

No

105

Each

281.0000

6

12

✓

NAS1149C.0532R

WASHER

**

115768

119736 JB

12/04/25

Location

Loc Qty

Loc Code

ST297

281

116373

1

116513

53

118384

227

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 76457

76457

Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0563R

Purchased

No

105

Each

370.0000

6

12

NAS1149C0563R

Washer

**

Location

Loc Qty

Loc Code

ST297

370

116391

182

117460

188

6x116391
6x117460

fb ✓ 12/04/25

November-15-11 8:03:51 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D407-802-1
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5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A
Date: 10.10.13